

Work Order ID 50270

July 14, 2009 11:12:41 AM



Page 1

Item ID: D3564-13 **GY** Accept

Revision ID: D

Item Name: Wearshoe

Start Date: 7/15/09 Start Qty: 22.00

Required Date: 7/15/09 Req'd Qty: 22.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: mf Date: 09-07-15 Tooling:

QC: Date: SPC (Y/N):

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3564	Rev D

100 0.00



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

I-Cut as per Dwg D3564 ☒ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Deburr if necessary

110 0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

120 0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

HB 9-7-08

HB 9-7-08

27

2) 5014268

counted
422

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50270

July 14, 2009 11:12:41 AM



Page 2

Item ID: D3564-13

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 7/15/09 Start Qty: 22.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 22.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT 8179

EP07/07/09 *(27)*

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) 502/4/09

countes
(402) *φ*

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: *2:30pm* FINISH TIME: *2:60pm* OVEN TEMPERATURE: *320°F*

M109091 09 07-29 *(22)* *ll*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50270

July 14, 2009 11:12:41 AM

Page 3

Item ID: D3564-13

Accept

Revision ID: D

Item Name: Wearshoe

Start Date: 7/15/09 Start Qty: 22.00

Required Date: 7/15/09 Req'd Qty: 22.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09-07-30

22

170

Identify as per dwg & Stock Location:

FR-17

0.00



Packaging

Memo

0.00

Packaging

=> 09-07-30 X22

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/30 30-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:12:40 AM

Work Order ID: 50270



Parent Item: D3564-13RevD



Parent Item Name: Wearshoe

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 22.00

Required Qty: 22.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	117.5511	5.1411	27		
304/316 Sheet .063												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	117.5510527	
106860	17	
111323	2.21	
111924	98.3410527	

111924 HB 9-7-08

27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

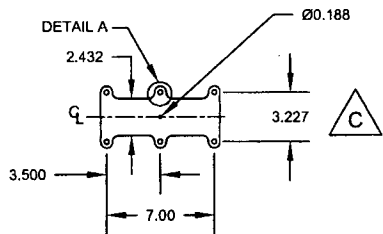
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

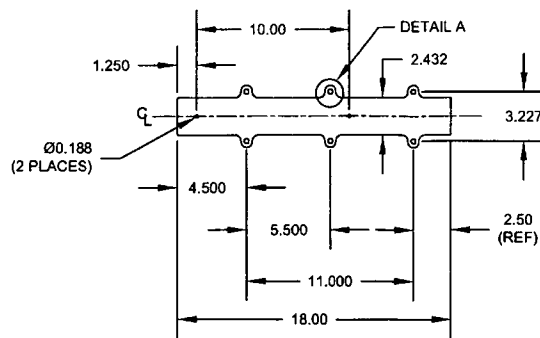
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

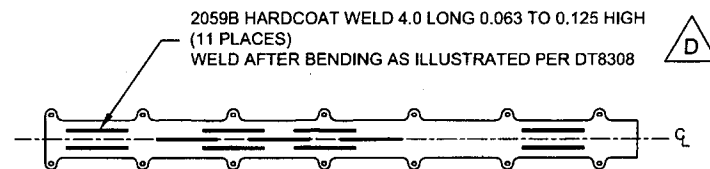
8 7 6 5 4 3 2 1



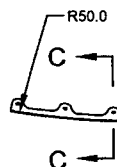
D3564-13F FLAT PATTERN



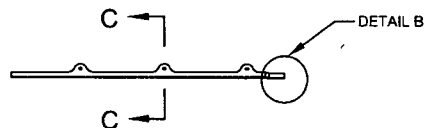
D3564-15F FLAT PATTERN



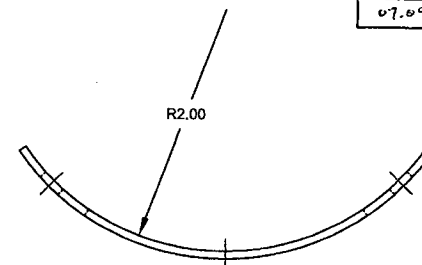
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



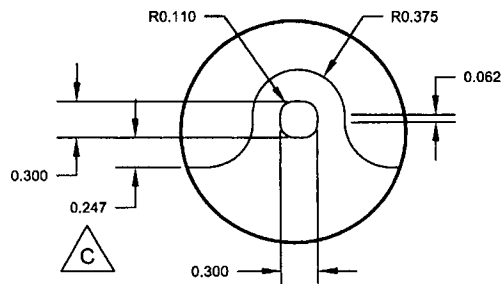
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



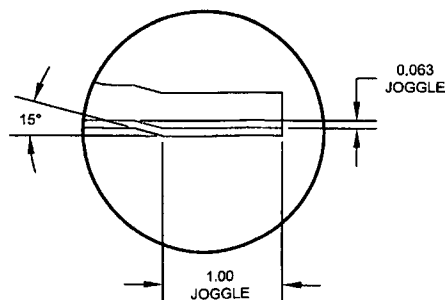
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED

07.09.04

SECTION C-C SHOP COPY
SCALE 1:1
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50270
ME 09-07-15

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	PH	DRAWING NO.	REV. D
DRAWN	CB	D3564	SHEET 3 OF 3
CHECKED	PH	TITLE	SCALE
MFG. APPR.	PH	WEARSHOE	1:8
APPROVED	PH	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
DE APPR.	PH	(THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.)	
DATE	07.08.21		